

538

SPLIT-1

DART AEROSPACE LTD		Work Order:	23987
Description: Clevis		Part Number:	B67-43001-109
Dwg: B67-43001 Rev. B page 32		Qty:	20
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	SP	05/08/2020	
2	ML	Turn as per Dwg B67-43001 Material: 6061-T6 Bar Ø1.00 (QQ-A-200/8 or QQ-A-225/8) (M6061T6R1.000) Identify for B67-43001-109	Dwg Rev: B 718147 Batch: M17881	ML	05/09/04 20
3	QC2	Inspect parts as they come off the machine Identify as B67-43001-109	ML	05/09/04	20
4	MM	Mill as per Dwg B67-43001	ML	05/09/17	20
5	QC2	Inspect parts as they come off the machine	ML	05/09/17	20
6	QC8	Second check	EN	05/09/18	20
7	MM	Deburr	ML	05/09/17	20
8	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	05/09/19	20
9	FP	Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3 Mask round section			
10	QC3	Inspect Powder Coat	SP	05/10/06	20
11	ST	Identify and Stock	CD	05/10/06	15
12	AC	Cost / part: 11.43	SAC	05/10/13	15
13	DC	Close W/O 11.43 Inspect Level 21	DA	05/10/12	15

Rev	Date	Change	Revised By	Approved
A	05.08.26	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
05/08/2020

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05.10.06	9+10	REMOVE STEPS AS PART IS BEING PAINTED ONCE MOUNTED ON A TUBE WITH	EC	05.10.12		AB 05.10.12	AB 05.10.12
		Permanent Change					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

DQA:

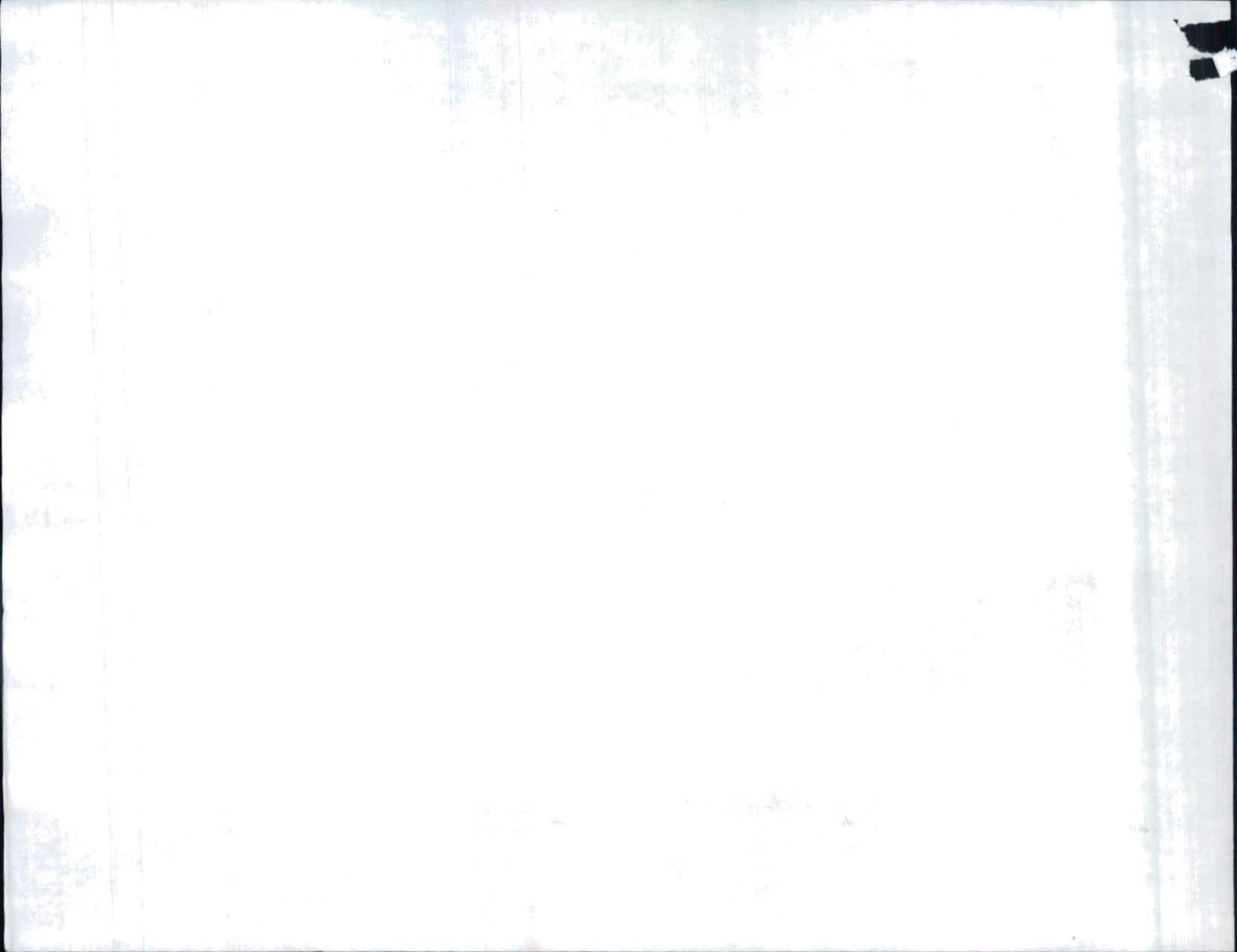


Date: 05/10/12

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____



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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 09, 2005
11:26 am

Work Order No : 0023987
Project Name : pB67-43001-109 X Department Code:
Project For : WK538 Burden Flags : NNNNNNN
Work Order Type : Main WO Status : Open
Main WO Number : Invoice State : Not Invoiced
House Part Number : pB67-43001-109 Invoice Date :
Description : Invoice Number :
Manufactured : No Invoice Amount : 0.00
Amount Req'd : 20
Amount Done : 0 Order Entry No :
Start Date : 08-09-05 OE Value : 0.00
Est Finish Date :
Act Finish Date : Est Margin : 0.000%
Drawings Reqd : No Actual Margin : 0.000%
Ok for Approval :
Approval Rec'd : \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

DART AEROSPACE LTD	Work Order:	23987
Description: Clevis	Part Number:	B67-43001-109
Inspection Dwg: B67-43001 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.25	$\pm .030$	0.245	✓	—	—	—
2.30	$\pm .030$	2.306	—	—	—	—
0.860	$\pm .005$	0.857	—	—	—	—
0.75	$\pm .030$	0.750	—	—	—	—
0.10	$\pm .030$	0.105	✓	—	—	—
1.15	$\pm .030$	1.157	—	—	—	—
0.10	$\pm .030$	—	—	—	—	—
0.10	$\pm .030$	—	—	—	—	—
$\varnothing 0.250$	$\pm .005$ $\pm .001$	$\varnothing 0.251$	—	—	—	—
R0.50	$\pm .030$	R0.50	✓	—	—	—

Measured by:	<i>ml</i>	Audited by:	<i>E</i>	Prototype Approval:	
Date:	<i>05/09/17</i>	Date:	<i>05.09.17</i>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	



